

Work Order ID 56695

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March 4, 2010 12:42:38 PM

Item ID: D3703-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Doubler

Start Date: 3/05/10

Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10

Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

*PL*Date: *10-3-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3703

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3703 ☒ Dwg Rev: *A* ☐ Prog Rev: *A**IR 10-3-10**6061. 063*☐****grain direction along 6.30**** ☐ 2- Debur if necessary*(7)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IR 10-3-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*5.10/03/10**(7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56695

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Item ID: D3703-1

Accept



Setup Start



Revision ID:

Item Name: Aft Doubler

Stop



Start Date: 3/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Brake NC

Memo

Bend as per Dwg D3703

0.00

SRS 10/03/12

(7)

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sols 1/5

0.00

(47)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

21 10/03/16

0.00

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56695

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Item ID: D3703-1

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Setup Start



Revision ID:

Item Name: Aft Doubler

Stop



Start Date: 3/05/10 Start Qty: 5.00



Cust Item ID:

Required Date: 3/12/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-16

(7)

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location UFS

0.00

Memo

0.00

P10/3/22 (7)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24 (7)

N10-3-22 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56695

Parent Item: D3703-1

Parent Item Name: Aft Doubler


Comments: IPP Rev:A 08-04-24 new issue DD verified by:EC

Start Date: 3/05/10

Required Date: 3/12/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No				sf	295.7841	3.6000	5.1		

IB 10-3-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	295.7841211	
110551	18.1841211	
113608	277.6	

⑦

113608

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3703-5 AFT CAP

D3703-3 AFT CORNER DOUBLER

D3703-1 AFT DOUBLER

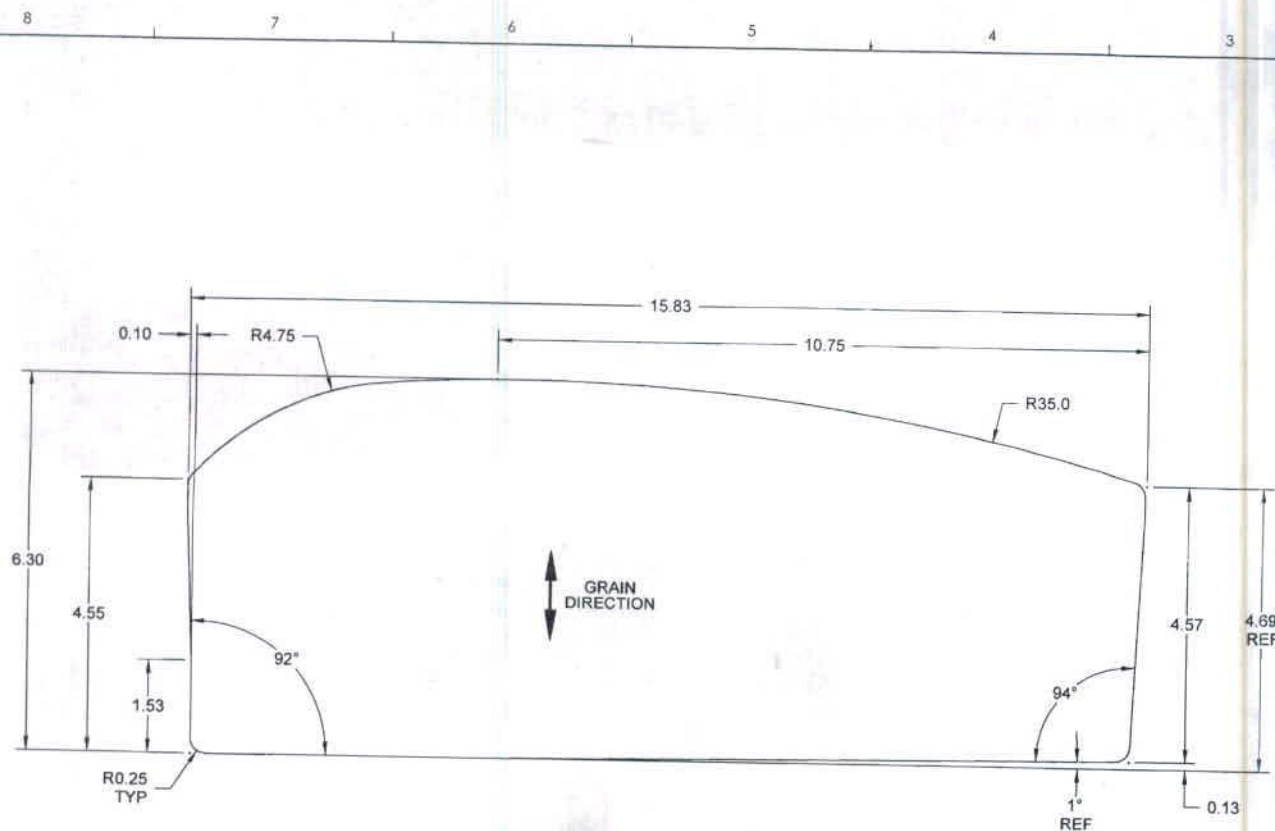
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
- 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

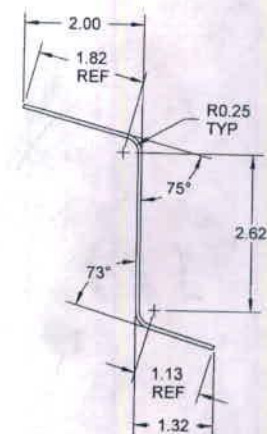
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54095
B710-3-04

RELEASED
09/14/09 MD

A NEW ISSUE		MB	08.04.30
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
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D3703-1F AFT DOUBLER FLAT PATTERN

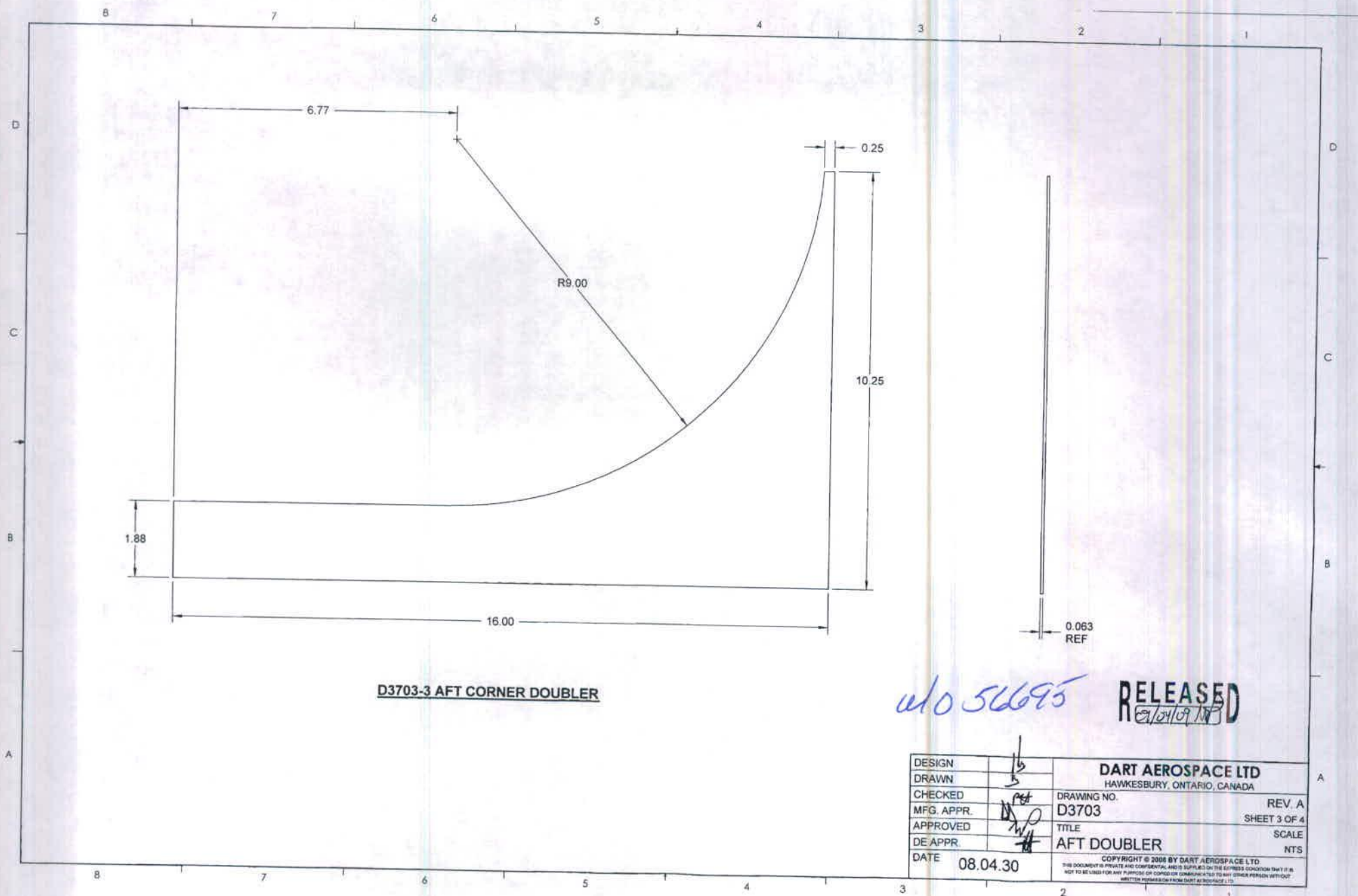


**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

W/O 56695

RELEASED
09/09/08

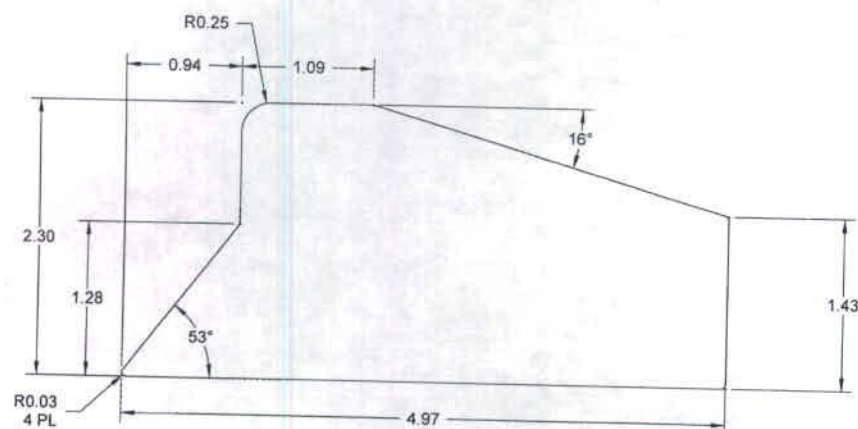
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CHECKED	<i>[Signature]</i>	DRAWING NO. D3703	REV. A
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405695

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2/2/09

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D3703-5 AFT CAP

w/o 56695

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09/04/09

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MFG. APPR.		TITLE AFT DOUBLER	SHEET 4 OF 4
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